

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013223**Date Inspected:** 14-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Cheng/Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Visual Testing before Galvanizing

This QA performed Visual Testing (VT) of Cat Walk hand rail before galvanizing. The Cat Walk designation numbers are as follows:

Type 6-Cat Walk 1 Piece.

Type 11-Cat Walk 6 Piece

Type 2-Cat Walk 3 Piece

Bay#19

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SB008-046)-B-CWR1246

Bay#19

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SB008-046)-B-CWR1246

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay#14

SMAW welding of weld joint Seg072A-026 located on Segment11DE. Welder is identified as 038740 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg072A-024 located on Segment11DE. Welder is identified as 067656 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg072A-0016 located on Segment11DE. Welder is identified as 066261 (4G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Bay#19

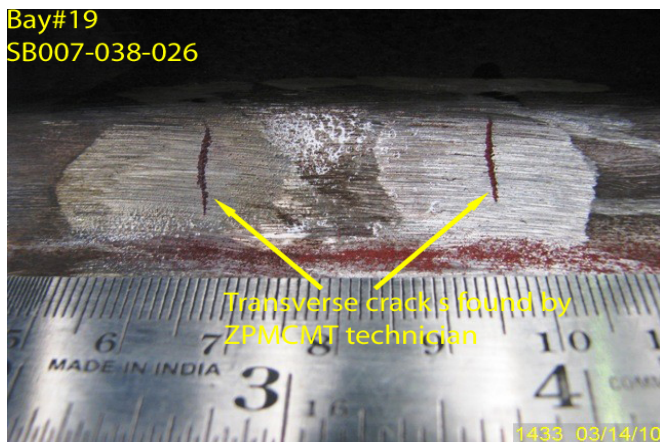
Weld repair performed by SMAW welding of weld joint SB007-036-004, B-CWR1309 located on SB007-036. Welder is identified as 062772 (3G). ZPMC QC is identified as Li ming yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-Repair.

Weld repair performed by SMAW welding of weld joint SB008-036-004, B-CWR1298 located on SB007-036. Welder is identified as 062772 (3G). ZPMC QC is identified as Li ming yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-Repair.

Bay#19

During random witness of magnetic particle inspection performed by ZPMC MT technician, This QA inspector observed that ZPMC MT technician found total two transverse indications. The weld is identified as SB007-038-026. The OBG component is identified as Suspender Bracket. Two crack measured approximately 8~10mm in length. ZPMC personal were grinding out the indications. For further information, Please find attached pictures.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------